Refinishing Procedures

1. Base material reconditioning (sanding)

-1. Repaint the replacement part
Lightly sand the part with #400, #600 or #800.

-2. Slight scores or scratches
Use a flexible sanding block, wet sand the damaged section with #400, #600 sandpaper.
NOTE: Sand level to remove damage.

-3. Deep scratches when filling.
Use a flexible sanding block and wet sand the damaged section with #240, #400 sandpaper.

2. Degreasing and cleaning

Clean the repaired area with wax and grease remover, then blow with compressed air.

⚠ WARNING

- **Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm^2, 30 psi) air nozzle.**
- **Wear goggles or safety glasses to prevent eye injury.**

NOTE: Wipe dust off surface with a tack cloth.

3. Filling, drying, and sanding

Apply the filler in several thin coats.
NOTE: Mix and apply the filler according to the manufacturer's instructions.

-1. Dry the filler with an infrared dryer for 5 or 6 minutes.
Be sure to keep the dryer 40-50 cm (16-20 in) away from the surface.

-2. Scratch the filled surface with your nail. If the surface is white when scratched, dry sand and wet sand with the #240-#400 sandpaper. Be sure to sand level.

4. Cleaning with compressed air, and degreasing

Blow the entire area to be coated with compressed air, then clean with wax and grease remover.

⚠ WARNING

- **Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm^2, 30 psi) air nozzle.**
- **Wear goggles or safety glasses to prevent eye injury.**

NOTE: Clean the whole surface to the help the masking tape adhere securely.

(cont'd)

ABS/PC Resin Parts

Refinishing Procedures (cont'd)

5. Masking

Use the masking tape and paper to mask the area that should not be sprayed.

6. Coat with primer/primer surfacer, followed by drying and sanding.

- Spray the primer surfacer over the filled area.

⚠WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it a away from sparks, flames, or cigarettes.**
- **Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm^2, 30 psi) air nozzle.**
- **Wear goggles or safety glasses to prevent eye injury.**

- The coating thickness should be 20-25 microns.

NOTE: Follow the primer/primer surfacer manufacturer's instructions.

-1. Drying

- Let the primer surfacer dry naturally for 5 to 10 minutes, then dry with a infrared dryer.

⚠WARNING Body parts being dried with an industrial dryer can get hot enough to cause injury. Do not touch parts being dried.

- Be sure to keep the dryer 40-50 cm (16-20 in) away from the paint film.

-2. Sanding

Lightly dry sand the whole area to be painted with #600, #800 sandpaper.

7. Blow off with compressed air, then clean with wax and grease remover.

⚠WARNING

- **Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm^2, 30 psi) air nozzle.**
- **Wear goggles or safety glasses to prevent eye injury.**

NOTE: Clean the whole surface to help the masking tape adhere securely.

8. Top coating

- Remove dust with a tack cloth before spraying.
- Spray the top coating. Spray until the primer surfacer is covered.
- The coating thickness should be 30-35 microns.

⚠WARNING

- **Ventilate when spraying paint. Most paint contains substances that are harmful if inhaled or swallowed. Read the paint label before opening the paint container.**
- **Avoid contact with skin. Wear an approved respirator, gloves, eye protection, and appropriate clothing when painting.**
- **Paint is flammable. Store it in a safe place, and keep it a away from sparks, flames, or cigarettes.**
- **Do not use high air pressure; use only an approved, 210 kPa (2.1 kgf/cm^2, 30 psi) air nozzle.**
- **Wear goggles or safety glasses to prevent eye injury.**

NOTE: For the recommended top coat paint, refer to "Example of repair materials".

Solid color: Color enamel + color clear coat

Metallic: Metallic enamel + clear coat

Pearl: Pearl enamel + clear coat

9. Drying

After top coating for about 10 minutes, then dry with an infrared dryer.

NOTE: Follow the paint manufacturer's specification to dry properly.